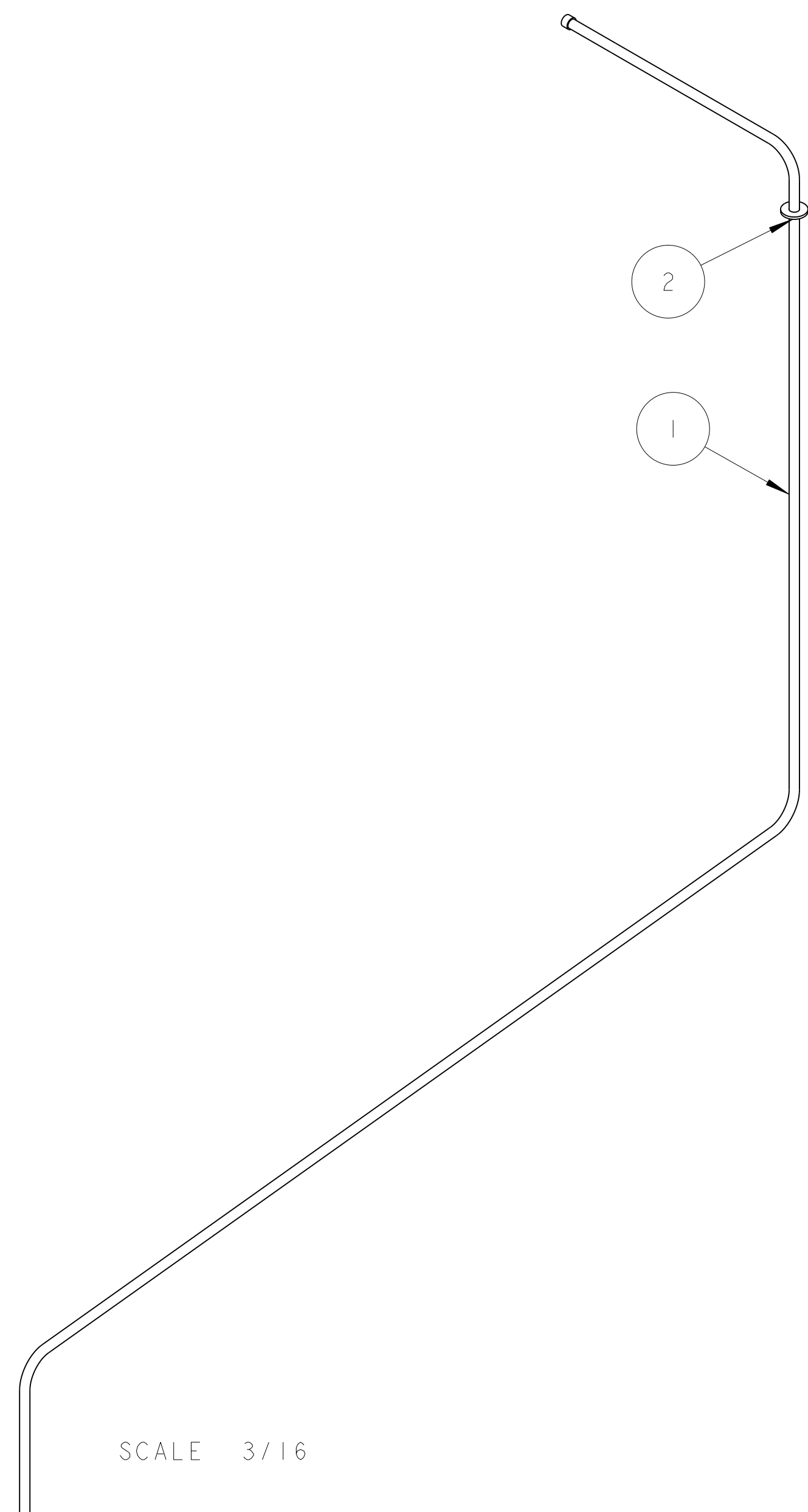


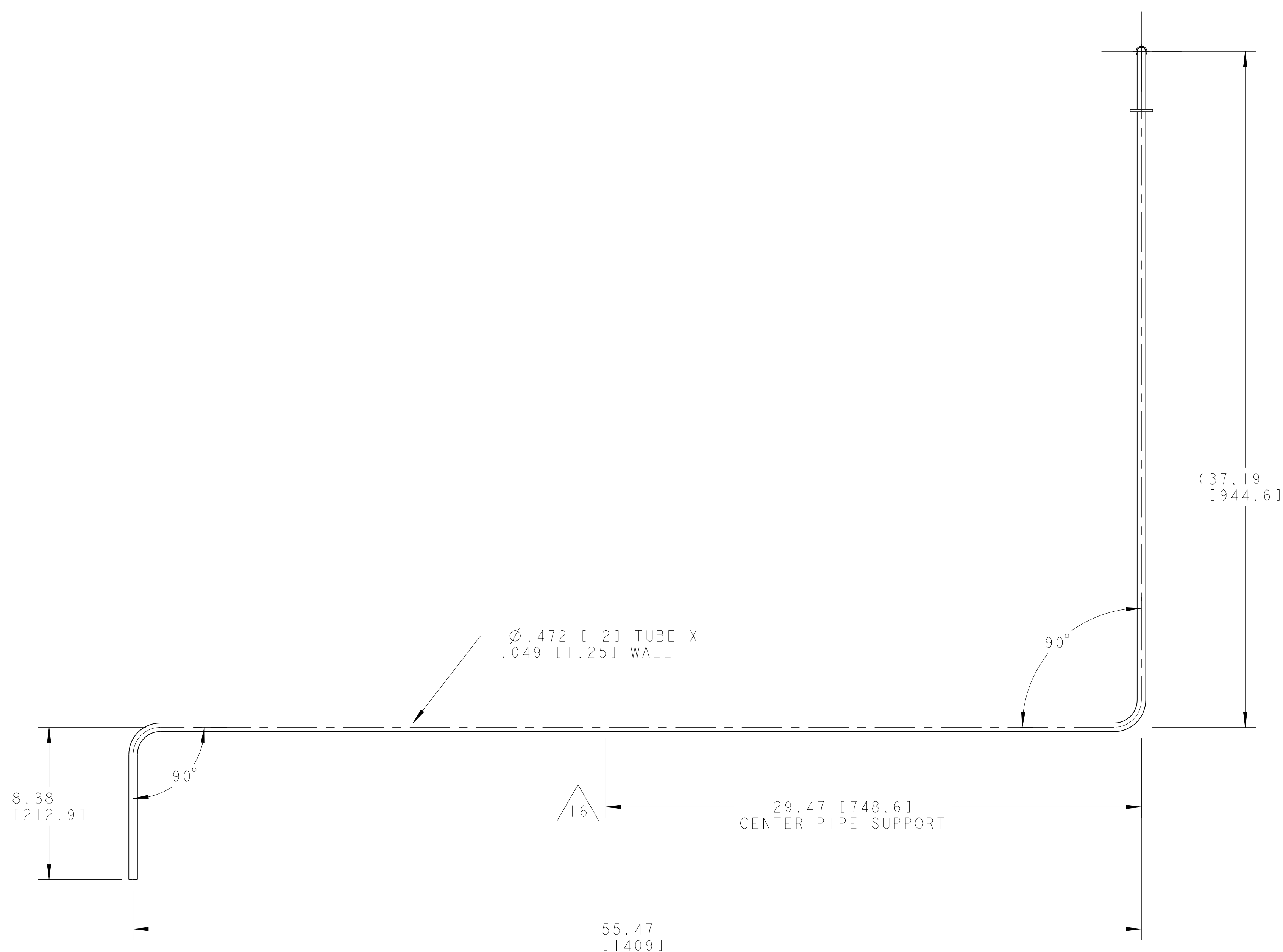
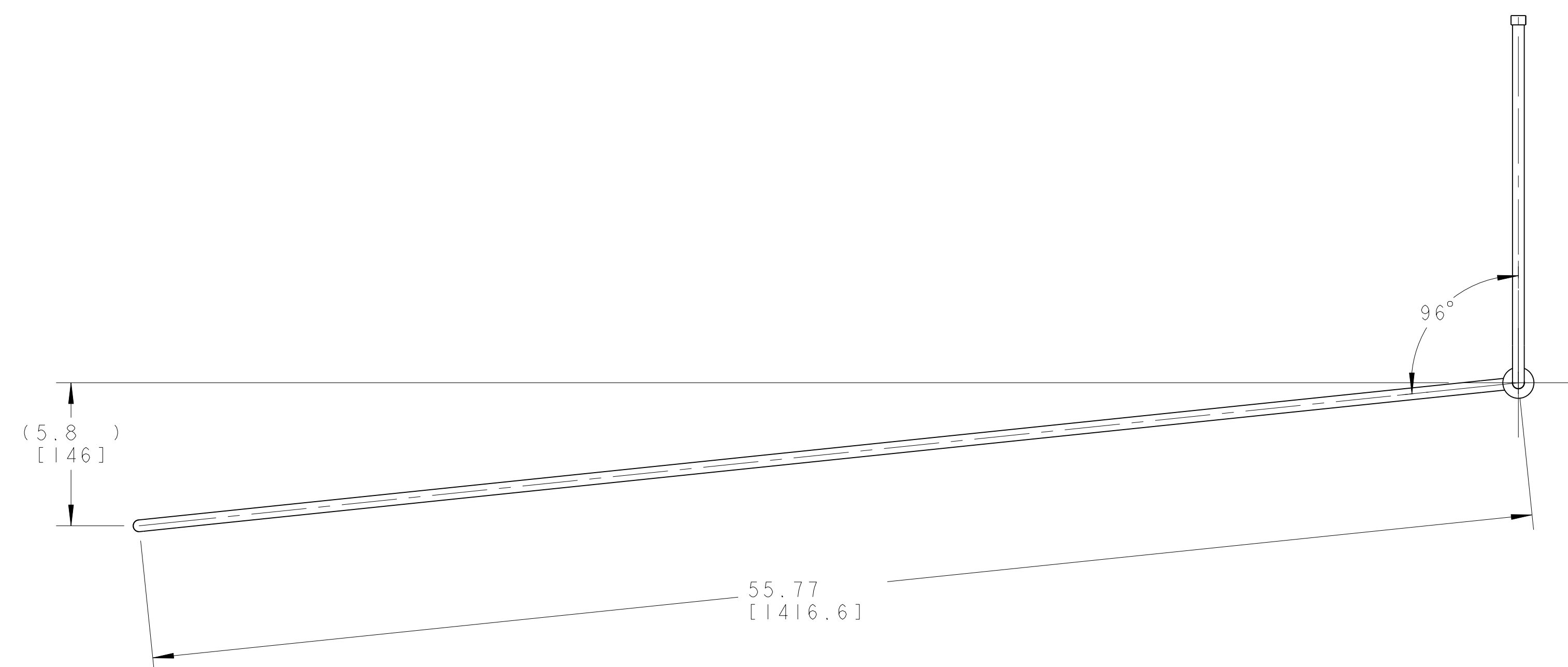
1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:  
PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.  
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,  
OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER  
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES  
ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO  
LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE  
FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY  
AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS  
WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. (B)
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING  
FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH  
THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL,  
TO AN ACCURACY OF  $\pm 0.063$ ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE  
ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR  
PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX  
ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE  
OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)



Technical drawing of a 90-degree elbow fitting. The drawing shows the profile of the fitting with dimensions in inches and millimeters (in brackets). Key dimensions include:

- Overall length: 14.7 [373]
- Installed length: 11.70 [297.2]
- Flange thickness: 7.20 [182.9] (QRL FLANGE)
- Radius: 4X R1.50 [38.1]
- 90° bend angle
- Inner diameter: Ø 1.25 [31.8]
- Flange width: 1.13 [3.3]
- Flange offset: 3.31 [84.1]
- Overall height: 37.19 [944.6]
- Overall width: 45.57 [1157.5]
- Bottom offset: 5.75 [146.1]

Callouts 14, 15, and 17 indicate specific features or welds.



<div style="display: flex; justify-content: space-between;"> <div> <p>UNLESS OTHERWISE SPECIFIED</p> <p>1. X ± 0.1      I/FAC ± 1/64</p> <p>1. XX ± 0.3      Angles ± 1.00°</p> <p>1. XXX ± 0.010      FINISH 125 <math>\mu</math>in</p> </div> <div> <p><b>SHOP ORDERS</b></p> <p>ALL DIMENSIONS TO BE SHOWN ON SHOP DRAWINGS</p> <p>SURFACES TO BE FINISHED TO THE FOLLOWING TOLERANCES</p> <p>IDENTIFY TAG</p> <p>PROTECT N/A</p> <p>WELDING N/A</p> <p>PROJECT N/A</p> <p>DATE 11/1/01</p> </div> <div> <p><b>ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY</b></p> <p>UNIVERSITY OF CALIFORNIA, BERKELEY</p> <p>LHC IR FEEDBOX</p> <p>CRYOGENICS</p> <p>PIPE, CCI</p> </div> </div>									
<p><b>DO NOT SCALE PRINT</b></p> <p>CHAMFER DINGS OF ALL SCREW THREADS 30°</p> <p>OUT ROUND, 1.5 THREAD RADIUS ON MACHINED THREADS</p> <p>ALL DIMENSIONS TO BE SHOWN ON SHOP DRAWINGS</p> <p>REMOVE BORE, MELD SLOPE AT 1:4 RATIO</p> <p>IN ACCORDANCE WITH ASME Y14.5-1994</p>									
B	ARH	SPV	01/17/03	REVISED DRAWING NOTES 13, 16 & 17			<p>DATE 12-Dec-01</p> <p>ASSEM</p>		<p>SCALE: 1/4</p> <p>SHEET 1 OF 1</p>
A	ARH	SPV	11-01-02	INITIAL RELEASE			<p>DATE 08-Aug-02</p> <p>75LC52</p>		<p>DO NOT SCALE</p> <p>RE</p>
REV	DWG	CHK	ZHK	DATE	CHANGES			<p>PATENT CLEAR:</p> <p>DESIGN ACCT: 12</p> <p>CATEGORY CODE: 1</p> <p>DWG. NO: 2515196</p> <p>SIZE: RE</p>	